

## DESCRIPTION

~~LEATHER COATED WITH FLUORINE-CONTAINING RESIN~~

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## TECHNICAL FIELD

The present invention relates to a leather coated with a fluorine-containing resin being excellent in stain-proofing property (stain-removability) and solvent resistance, a production method thereof and a leather product produced by using the coated leather.

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## BACKGROUND ART

There are various methods of finishing a surface of a leather depending on kind of a raw leather and application of leather products. Except un-finished leathers such as fur, suede and nubuck, a resin coating film is formed on a surface of a leather for finishing. The resin coating film is formed for protection of a leather surface and for a good appearance thereof and in addition, for preventing a stain from soaking into a leather and for easily wiping off sweat and stain.

As a material for coating on a surface of a leather, non-fluorine-containing materials such as urethane resins, nitrocellulose lacquer, proteins such as casein, and higher fatty acid ester wax are used. Among them, urethane resins are excellent in adhesion, flexibility, transparency, bending resistance, cold resistance, chemical resistance, heat resistance and abrasion resistance and are widely used.

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However conventional coating films are hydrophilic or hydrophobic. In case of the former hydrophilic film, aqueous stains such as mud and soy sauce easily adheres thereto, and in case of the



latter hydrophobic film, oily stains such as sebaceous matter, rouge and ink of ball-point pen easily adheres. Those stains are difficult to be removed by wiping, etc. For the same reason, solvent resistance is also not sufficient.

5           On the other hand, while a fluorine-containing resin coating film is excellent in water- and oil-repellency and solvent resistance, it is inferior generally in flexibility and poor in adhesion to a leather surface or a primer coating film. Therefore it has been considered that the fluorine-containing resin coating film is not practical as a coating film for  
10 a leather which is demanded to have a high flexibility.

          An object of the present invention is to provide a leather material and leather product having improved stain-proofing property, (stain removability) and solvent resistance while making the best use of feeling of the leather product and maintaining required properties, for  
15 example, flexibility, cold resistance and bending resistance.

          The inventors of the present invention have made studies with respect to the fluorine-containing resin coating film which has been considered impractical and as a result of trial and error, have found that when the fluorine-containing resin coating film having a reactive curable  
20 group is used, the above-mentioned objects are attained and stain-proofing property and solvent resistance which have not been obtained before can be imparted to a leather.

#### DISCLOSURE OF INVENTION

25           Namely the present invention relates to a leather coated with a fluorine-containing resin which has a fluorine-containing coating film as an outermost layer formed on a surface thereof, in which in stain



removing test according to JIS L 0805, a grey scale is grade 4 or more and in ethanol resistance test according to JIS K 6547 by using a clock meter type friction tester, an area of chipped-off fluorine-containing coating film is 50 % or less.

5           In the preferred leather of the present invention, cracking does not arise on the fluorine-containing coating film in a cold resistance test in which the coated leather is allowed to stand at -5°C for 24 hours and then folded with a coated surface being faced outward, and also cracking does not arise on the fluorine-containing coating film when the  
10       coated leather is folded 30,000 times by using a flexometer described in JIS K 6545.

          It is preferable that a weight of the fluorine-containing resin coating film is not less than 2 g/m<sup>2</sup>.

          Each test used herein is carried out by the following methods  
15       and the results thereof are evaluated as follows.

(1) Stain removing test

          A coating composition to be tested is coated in a specified amount on a white cowhide (having a urethane resin coating film of 10 g/m<sup>2</sup> as a primer layer) by using a spray gun (a small size spray gun  
20       W-88 available from ANEST IWATA CORPORATION) and cured at 50°C for two minutes to give a coated leather. To the coated leather is applied staining substances mentioned hereinafter, followed by allowing to stand for 30 minutes. Then the stain adhered on the coated leather is wiped softly five times with a cotton cloth impregnated with a  
25       commercially available stain removing agent mentioned hereinafter. A floating stain is wiped off sufficiently with a cotton cloth which is not impregnated with a stain removing agent. Then a state of stain



remaining on the leather surface is compared (with naked eyes) to a grey scale for staining of JIS L 0805.

The grey scale for staining of JIS L 0805 is classified into nine grades, namely from grade "1" of the most stained degree through "1-2",  
5 "2", "2-3", "3", "3-4", "4", "4-5" up to "5" of the most stainless degree for evaluation of staining degree.

Staining substance

Kind of stain

10 Rouge: "CALIFORNIA COLORS No. 4" available from NIHON KOLMAR CO., LTD.

Mustard: Mustard for hot dog available from Q.P. CORPORATION

15 Ball-point pen: Oil ink ball-point pen (black) SOFT STAINLESS SA-S available from MITSUBISHI PENCIL CO., LTD.

Stain removing agent

Detergent: Diluted aqueous solution of 30 % by weight of neutral synthetic detergent "MAMA ROYAL NATUR" available from LION CORPORATION

20 Cleaner for leather: "MERCI CLEANER" available from SANETCHI K.K.

(2) Ethanol resistance test

A coating composition to be tested is coated in a specified amount on a dark blue cowhide (having a urethane resin coating film of  
25  $20 \text{ g/m}^2$  as a primer layer) by using a spray gun (the same one as used in the stain removing test) and cured at  $50^\circ\text{C}$  for two minutes to give a coated leather. Some drops of an aqueous solution of 75 % by weight of



ethanol are put on a surface of the coated leather, and after allowing to stand for three minutes, are soaked up with a paper. Immediately after that, the leather surface where the droplets of ethanol has been put is rubbed with a dry white cotton cloth five times by using a clock meter type friction tester described in JIS K 6547, and an area percentage of coating film chipped off is evaluated with naked eyes.

(3) Cold resistance test

A coated white cowhide produced in the same manner as in the above-mentioned stain removing test is kept in a refrigerator of  $-5^{\circ}\text{C}$  for 24 hours. Immediately after taken out, the coated leather is folded with the coated surface being faced outward. In the folded state, a red aqueous ink is applied to the folded part and immediately wiped off softly and unfolded. Cracking on the coating film is evaluated with naked eyes (if there is a cracking, it appears by a red line).

(4) Flexing fatigue resistance test

After a coated white cowhide produced in the same manner as in the above-mentioned stain removing test is bent 30,000 times by using a flexometer described in JIS K 6545, a red aqueous ink is applied to the bent part and immediately wiped off. Then cracking on the coating film is evaluated with naked eyes (if there is a cracking, it appears by a red line).

The leather coated with a fluorine-containing resin of the present invention can be produced by applying a curable fluorine-containing resin coating composition comprising a fluorine-containing resin having a reactive curable group and a curing agent to a leather directly or through a primer layer and then curing a coating film.

Example of the preferred reactive curable group of the



fluorine-containing resin having the curable reactive group (hereinafter referred to as "curable fluorine-containing resin") is at least one of hydroxyl group, amino group, epoxy group, carboxyl group, mercapto group, hydrolyzable silyl group, amido bond, urethane bond and urea bond. Particularly preferred is hydroxyl group. It is preferable that a hydroxyl value of a fluorine-containing resin having hydroxyl group is not more than 200 mgKOH/g.

Preferable examples of a trunk chain of the curable fluorine-containing resin are polymers having at least one of a recurring unit of chlorotrifluoroethylene unit, tetrafluoroethylene unit, trifluoroethylene unit, hexafluoropropylene unit, vinylidene fluoride unit and vinyl fluoride unit.

Examples of the curing agent to be used are an isocyanate compound, amino resin, acid anhydrides, polysilane compounds, polyepoxy compounds and silane compounds having isocyanate group.

As mentioned above, the fluorine-containing resin coating film may be formed on a leather surface directly or through a primer layer. When the coating film is formed through a primer layer, it is preferable to use, as a material for the primer layer, an acrylic resin, methacrylic resin, urethane resin, acrylonitrile resin, butadiene resin, styrene resin, vinyl chloride resin, vinylidene chloride resin, vinyl acetate resin or a mixture of two or more thereof.

Further the present invention relates to various leather products having the above-mentioned leather coated with a fluorine-containing resin, for example, interior goods for vehicle and building, furniture, shoes, bags, clothes, small leather articles, etc.



## BEST MODE FOR CARRYING OUT THE INVENTION

The fluorine-containing resin coating film formed as the outermost layer of the leather coated with the fluorine-containing resin coating composition of the present invention can be obtained by  
5 applying the curable fluorine-containing resin coating composition comprising a curable fluorine-containing resin having a reactive curable group and a curing agent to a leather and then curing it.

Examples of the reactive curable group of the curable fluorine-containing resin are, as mentioned above, hydroxyl group,  
10 amino group, epoxy group, carboxyl group, mercapto group, hydrolyzable silyl group (for example, trimethoxysilyl group, triethoxysilyl group, etc.) amido bond, urethane bond and urea bond. Particularly hydroxyl group is preferred from the viewpoint of stability of the resin and curing reactivity. It is preferable from the viewpoint of feeling of a coated  
15 leather and flexing resistance that hydroxyl group is introduced so that a hydroxyl value is not more than 200 mgKOH/g.

For example, concretely there are curable fluorine-containing resins described in JP-B-60-21686, JP-A-3-121107, JP-A-4-279612, JP-A-4-28707, JP-A-2-232221, etc. With respect to a molecular weight,  
20 it is preferable from the viewpoint of curability and workability at coating work that a number average molecular weight (measured with GPC) is from 1,000 to 500,000, particularly 1,500 to 100,000.

The curable fluorine-containing resins are those containing chlorotrifluoroethylene (CTFE) unit, tetrafluoroethylene (TFE) unit,  
25 trifluoroethylene (TrFE) unit, hexafluoropropylene (HFP) unit, vinylidene fluoride (VDF) unit or vinyl fluoride (VF) unit preferably in an amount of not less than 20 % by mole. Particularly curable fluorine-containing



resins containing in an amount of 20 to 60 % by mole are preferred from the viewpoint of stain-proofing property and solubility in a solvent.

Examples of the usable curable fluorine-containing resin commercially available are, for instance, organic solvent type fluorine-  
5 containing resin coating compositions such as ZEFFLE GK (trade name) series available from DAIKIN INDUSTRIES, LTD., LUMIFLON (trade name) series available from ASAHI GLASS CO., LTD., CEFRAL COAT (trade name) available from CENTRAL GLASS CO., LTD., FLUONATE (trade name) series available from DAINIPPON INK AND CHEMICALS,  
10 LTD., and ZAFLON (trade name) series available from TOAGOSEI CO., LTD.

The curable fluorine-containing resin may be blended with other resins, for example, one or two or more of a styrene resin, (meth)acrylic resin, polyester resin, alkyd resin,  
15 melamine/formaldehyde resin, polyisocyanate resin, epoxy resin, vinyl chloride resin (for example, vinyl chloride/vinyl acetate copolymer, etc.), ketone resin, petroleum resin, chlorinated polyolefins such as chlorinated polyethylene and chlorinated polypropylene, inorganic resins such as silica gel and silicate, fluorine-containing resins other  
20 than the above-mentioned curable fluorine-containing resins of the present invention (for example, homopolymers of tetrafluoroethylene and chlorotrifluoroethylene and copolymers thereof with other monomer), and the like. The other resins are not limited to them.

The curing agent which is used in the present invention as an  
25 another component of the curable fluorine-containing resin coating composition may be one which reacts with the above-mentioned reactive curable group for curing of the fluorine-containing resin. For example,



isocyanate compounds, amino resins, acid anhydrides, polysilane compounds, polyepoxy compounds, isocyanate group-containing silane compounds, and the like are used usually.

Non-restricted examples of the isocyanate compound are, for instance, 2,4-tolylene diisocyanate, diphenylmethane-4,4'-diisocyanate, xylylene diisocyanate, isophorone diisocyanate, lysine methyl ester diisocyanate, methylcyclohexyl diisocyanate, trimethylhexamethylene diisocyanate, hexamethylene diisocyanate, n-pentane-1,4-diisocyanate, termonomers thereof, adducts and biurets thereof, polymers thereof having two or more isocyanate groups and blocked isocyanates.

Non-restricted examples of the above-mentioned amino resin are, for instance, urea resin, melamine resin, benzoguanamine resin, glycoluril resin, methylolated melamine resin obtained by methylolating melamine, alkyl-etherified melamine resins obtained by etherifying methylolated melamine with alcohol such as methanol, ethanol and butanol, and the like.

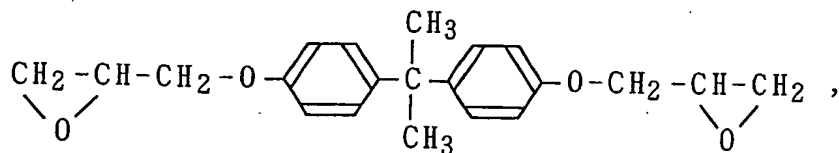
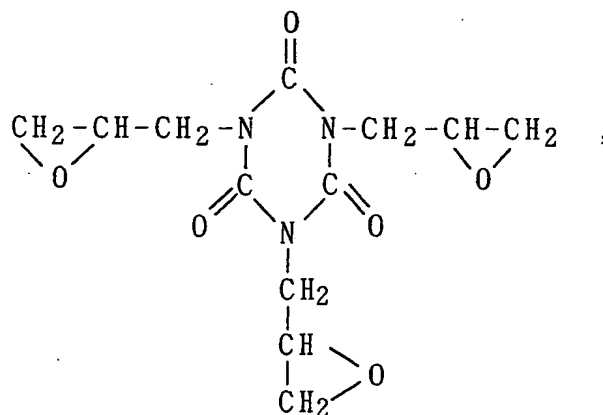
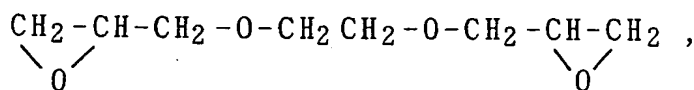
Non-restricted examples of the acid anhydride are, for instance, phthalic anhydride, pyromellitic anhydride, mellitic anhydride, and the like.

The polysilane compound is a compound having two or more groups selected from SiOH group and hydrolyzable group directly bonded to silicon atom or a condensate thereof, and the compounds described, for example, in JP-A-2-232250, JP-A-2-232251, etc. can be used. Examples thereof are dimethyldimethoxysilane, dibutyldimethoxysilane, diisopropyldipropoxysilane, diphenyldibutoxysilane, diphenylethoxysilane, diethyldisilanol, dihexyldisilanolmethyltrimethoxysilane, methyltriethoxysilane,



ethyltriethoxysilane, propyltrimethoxysilane, phenyltriethoxysilane, phenyltributoxysilane, hexyltriacetoxysilane, methyltrisilanol, phenyltrisilanol, tetramethoxysilane, tetraethoxysilane, tetrapropoxysilane, tetraacetoxysilane, diisopropoxydivaleroxysilane, 5 tetrasilanol, and the like.

Examples of the usable polyepoxy compound and isocyanate group-containing silane compound are, for instance, those described in JP-A-2-232250, JP-A-2-232251, etc. Examples of the suitable compounds are



25  $\text{OCNC}_3\text{H}_6\text{Si}(\text{OC}_2\text{H}_5)_3, \quad \text{OCNC}_2\text{H}_4\text{Si}(\text{OCH}_3)_3,$

and the like.



An adding amount of the curing agent is from 0.1 to 5 equivalents, preferably 0.5 to 1.5 equivalents to 1 equivalent of the reactive curable group in the above-mentioned curable fluorine-containing resin. The coating film can be cured usually at 0° to 200°C  
5 for about several seconds to about ten days.

To the coating composition to be used in the present invention can be added various additives. Examples of the additive are those usually used, such as a curing accelerator, pigment, pigment dispersing agent, dye, leveling agent, defoaming agent, gellation  
10 preventing agent, ultraviolet ray absorber, anti-oxidant, plasticizer and thickener.

Examples of the curing accelerator are, for instance, organotin compounds, alkyl acid phosphates, reaction products of amine with alkyl acid phosphates, saturated or unsaturated polyvalent  
15 carboxylic acids or acid anhydrides thereof, organotitanate compounds, amine compounds, lead octylate, and the like.

The curing accelerators may be used solely or in a mixture of two or more thereof.

An adding amount of the curing accelerator is preferably from  
20 about  $1.0 \times 10^{-6}$  parts by weight to about  $1.0 \times 10^{-2}$  parts by weight, further preferably from about  $5.0 \times 10^{-5}$  parts by weight to about  $1.0 \times 10^{-3}$  parts by weight on the basis of 100 parts by weight of fluorine-containing resin.

Non-restricted examples of the pigment are, for instance, an  
25 inorganic pigment such as titanium oxide, calcium carbonate or carbon black; an organic pigment such as phthalocyanine, quinacridone or azo pigment; and the like. An adding amount of the pigment is usually up



to about 200 % by weight based on the fluorine-containing resin.

In the present invention, the coating composition can be prepared in the form of organic solvent composition, water dispersible composition and non-water-dispersible dispersion. From the viewpoint  
5 of storage stability of dye and curing reactivity, organic solvent composition is preferred.

In case of the organic solvent composition, examples of the solvent are esters such as ethyl acetate, butyl acetate, isopropyl acetate, isobutyl acetate, cellosolve acetate and propylene glycol methyl ether  
10 acetate; ketones such as acetone, methyl ethyl ketone, methyl isobutyl ketone and cyclohexane; cyclic ethers such as tetrahydrofuran and dioxane; amides such as N,N-dimethylformamide and N,N-dimethylacetamide; aromatic hydrocarbons such as toluene and xylene; alcohols such as propylene glycol methyl ether; hydrocarbons such as  
15 hexane and heptane; solvent mixture thereof; and the like. A resin concentration is from 1 to 95 % by weight, preferably 5 to 70 % by weight.

The leather coated with the fluorine-containing resin coating composition of the present invention can be obtained by applying the  
20 above-mentioned curable fluorine-containing resin coating composition to the leather directly or through a primer layer and then carrying out curing.

For the primer layer, conventional primer resins can be used. For example, the primer layer is formed by applying a coating  
25 composition comprising an acrylic resin, methacrylic resin, urethane resin, acrylonitrile resin, butadiene resin, styrene resin, vinyl chloride resin, vinylidene chloride resin, vinyl acetate resin or a mixture of two or



more thereof. By forming the primer layer, smoothness and uniformity of appearance can be enhanced. Particularly preferred primer are urethane resin and acrylic resin. A coating amount of the primer layer may be selected optionally in a range of from 1 to 100 g/m<sup>2</sup> depending on application, kind of raw leather and surface condition of the leather.

A coating amount (solid content) of the cured fluorine-containing coating film which is formed as the outermost layer of the coated leather of the present invention may be optionally selected in a range of not less than 2 g/m<sup>2</sup>.

A coating method is not limited particularly as far as the above-mentioned coating thickness can be obtained. For example, spray coating, brush coating, curtain coating, roll coating, and the like method can be employed.

A curing method of a coating film differs depending on kinds of a curing agent and curing accelerator, a coating amount, application of the coated leather, etc. For example, there are (1) a method of allowing to stand at room temperature for five days, (2) a method of allowing to stand at 50°C for two minutes in a hot air drying oven, (3) a method of heating for 10 seconds with an infrared heater, and the like method.

Kind of a leather to be coated is not limited depending on kind of animal, a processing method, application, etc., and various kinds of leathers can be used. For example, there are leathers of animals such as cow, sheep, goat, pig, horse, kangaroo and deer. Examples of the surface finishing of the leather are full grain leather, corrected grain leather, pasted leather, embossing leather, shrink leather and patent leather.



The cured fluorine-containing coating film of the present invention is excellent in transparency, and when coating directly or through a transparent primer layer, it is possible to make the best use of a surface pattern of the leather. Also when a primer layer is colored by adding a pigment to the primer or when a pigment is added to the curable fluorine-containing resin coating composition for coloring, a tone of color of the pigment can be made vivid. Thus the leather of the present invention coated with the fluorine-containing resin coating composition is excellent in not only stain-proofing property, solvent resistance, cold resistance and flexing fatigue resistance but also a property for keeping a surface pattern.

Accordingly the leather of the present invention coated with the fluorine-containing resin coating composition can be processed into various leather products.

Examples thereof are, for instance, interior of building; interior of vehicles such as seat, head rest, arm rest, steering wheel, inner lining of door and lining of ceiling of automobile, seat and inner lining of aircraft, seat of train and seat of marine vessel; leather-covered furniture such as sofa, chair for living room and chair and table for dining room; shoes made of leather such as boots, pumps, men's shoes, sports shoes and safety shoes; leather bags such as knapsack, handbag, shoulder-strap bag, pouch, traveling bag and rucksack; leather wears such as skirt, overcoat, pants, jacket, motorcyclist's suits, ski suits, gloves and hat; small leather articles such as purse, belt, watch band, pocket notebook, harness and book cover; fabrics for handicraft; and the like. The leather product may be produced by cutting and sewing the coated leather of the present invention or forming into a leather product



and then coating.

Then the leather of the present invention coated with the fluorine-containing coating composition is explained by means of examples, but the present invention is not limited to them. "Part" and  
5 "%" represent "part by weight" and "% by weight", respectively.

#### EXAMPLE 1

A commercially available urethane resin coating for primer of a leather was coated on a white cowhide (chrome-tanned steer hide grain  
10 leather) with a spray gun to form a primer layer having a coating amount of 10 g/m<sup>2</sup>. Separately a curable fluorine-containing resin coating composition was prepared by adding 11 parts of CORONATE HX (hexamethylene diisocyanate curing agent available from NIPPON POLYURETHANE INDUSTRY CO., LTD.) to 100 parts of ZEFFLE GK500  
15 (TFE resin coating composition having hydroxyl group as a reactive curable group and being available from DAIKIN INDUSTRIES, LTD., Hydroxyl value of solid content of resin: 60 mgKOH/g, Acid value: 0 mgKOH/g) (NCO/OH=1) and then dispersing the mixture in 400 parts of butyl acetate.

20 The obtained coating composition was coated on the primer layer of white cowhide with a spray gun and cured at 50°C for two minutes to give the leathers of the present invention coated with the fluorine-containing resin coating composition which have an outermost layer of a fluorine-containing resin coating film of 2 g/m<sup>2</sup> and 10 g/m<sup>2</sup>  
25 (solid content), respectively.

With respect to the obtained white leathers coated with the fluorine-containing resin coating composition, the above-mentioned



stain removing test, cold resistance test and flexing fatigue resistance test were carried out. The results are shown in Table 1.

Further the leathers of the present invention coated with the fluorine-containing resin coating composition were obtained in the same manner as in the above-mentioned white cowhide except that a dark blue cowhide (chrome-tanned steer hide grain leather having 10 g/m<sup>2</sup> of urethane resin coating film as a primer layer) was used.

The above-mentioned ethanol resistance test was carried out by using the dark blue leathers coated with the fluorine-containing resin coating composition. The results are shown in Table 1.

#### EXAMPLES 2 to 13

White leathers coated with a fluorine-containing resin coating composition and dark blue leathers coated with a fluorine-containing resin coating composition were produced in the same manner as in Example 1 except that a curable fluorine-containing resin and a curing agent were changed to resins shown in Table 2 and mixed in a ratio of NCO/OH=1. A stain removing test, cold resistance test, flexing fatigue resistance test and ethanol resistance test were carried out. The results are shown in Table 2.

The resins used were as follows

- ZEFFLE GK-510: TFE resin coating composition having hydroxyl group available from DAIKIN INDUSTRIES, LTD., hydroxyl value of resin solid content: 60 mgKOH/g, acid value: 9 mgKOH/g
- ZEFFLE GK-550: TFE resin coating composition having hydroxyl group available from DAIKIN INDUSTRIES, LTD., hydroxyl value of resin solid content: 95 mgKOH/g, acid value: 0 mgKOH/g



LUMIFLON LF-200: CTFE resin coating composition having hydroxyl group available from ASAHI GLASS CO., LTD., hydroxyl value of resin solid content: 53 mgKOH/g, acid value: 0 mgKOH/g

TAKENATE D-177N: Hexamethylene diisocyanate curing agent available from TAKEDA CHEMICAL INDUSTRIES, LTD.

CORONATE 2094: Hexamethylene diisocyanate curing agent available from NIPPON POLYURETHANE INDUSTRY CO., LTD.

#### COMPARATIVE EXAMPLE 1

10           A white leather coated with a urethane resin coating composition and a dark blue leather coated with a urethane resin coating composition for comparison were produced in the same manner as in Example 1 except that a commercially available non-fluorine-containing urethane resin coating composition for finishing of a leather  
15           was used instead of the fluorine-containing resin coating composition. A stain removing test, cold resistance test, flexing fatigue resistance test and ethanol resistance test were carried out. The results are shown in Table 1.

#### COMPARATIVE EXAMPLES 2 and 3

20           A white leather coated with a fluorine-containing resin coating composition and a dark blue leather coated with a fluorine-containing resin coating composition were produced in the same manner as in Example 1 except that a curable fluorine-containing resin, a curing  
25           agent, a mixing ratio thereof and coating amount were changed as shown in Table 2, and tests were carried out. The results are shown in Table 2.



TABLE 1

Coating composition of outermost layer	Example 1		Comparative Example 1	
	Fluorine-containing resin (ZEFFLE GK-500) Curing agent (CORONATE HX)		Commercially available urethane resin coating composition for finishing of leather	
Coating amount (g/m <sup>2</sup> , solid content)	2	10	2	10
Stain removing test				
Rouge/detergent	4 - 5	5	3 - 4	3 - 4
Rouge/cleaner for leather	4 - 5	5	3	3 - 4
Mustard/detergent	4	5	3 - 4	3 - 4
Mustard/cleaner for leather	4 - 5	5	3 - 4	3 - 4
Ink of ball-point pen/detergent	4	4	3	3
Ink of ball-point pen/ cleaner for leather	5	5	3 - 4	3 - 4
Ethanol resistance test (area percentage % of coating film chipped off)	50	0	100	90
Cold resistance test (Cracking of coating film)	Nil	Nil	Nil	Nil
Flexing fatigue resistance test (Cracking of coating film)	Nil	Nil	Nil	Nil



TABLE 2

	Example						
	2	3	4	5	6	7	
Fluorine-containing resin used	ZEFFLE GK-510	ZEFFLE GK-510	ZEFFLE GK-550	ZEFFLE GK-550	LUMIFLON LF-200	LUMIFLON LF-200	
Curing agent used	TAKENATE D-177N	CORONATE 2094	TAKENATE D-177N	CORONATE 2094	TAKENATE D-177N	CORONATE 2094	
Mixing ratio							
Equivalent (NCO/OH)	1	1	1	1	1	1	
Coating amount (g/m <sup>2</sup> , solid content)	2	2	2	2	2	2	
Stain removing test							
Rouge/detergent	4 - 5	4 - 5	4 - 5	4 - 5	4 - 5	4 - 5	
Ink of ball-point pen/cleaner for leather	5	4 - 5	4 - 5	4 - 5	4 - 5	4	
Ethanol resistance test (area percentage % of coating film chipped off)	25	25	25	25	50	50	
Cold resistance test (Cracking of coating film)	Nil	Nil	Nil	Nil	Nil	Nil	
Flexing fatigue resistance test (Cracking of coating film)	Nil	Nil	Nil	Nil	Nil	Nil	

- continued -



- continued -

Example								Comparative Example		
8	9	10	11	12	13	2	3			
ZEFFLE GK-510	ZEFFLE GK-510	ZEFFLE GK-550	ZEFFLE GK-550	LUMIFLON LF-200	LUMIFLON LF-200	ZEFFLE GK-510	ZEFFLE GK-550			
TAKENATE D-177N	CORONATE 2094	TAKENATE D-177N	CORONATE 2094	TAKENATE D-177N	CORONATE 2094	CORONATE 2094	TAKENATE D-177N			
1	1	1	1	1	1	1	10			
10	10	10	10	10	10	0.5	10			
5	5	5	5	5	5	3 - 4	4			
5	4 - 5	5	4 - 5	4 - 5	4 - 5	3 - 4	4			
0	0	0	0	0	10	75	50			
Nil	Nil	Nil	Nil	Nil	Nil	Nil	Cracking occurred			
Nil	Nil	Nil	Nil	Nil	Nil	Nil	Cracking occurred			



As it is clear from Tables 1 and 2, stain removability against various stains are enhanced with respect to the leather coated with the fluorine-containing resin coating composition of the present invention.

Also cold resistance and flexing fatigue resistance are  
5 maintained, and solvent resistance is improved.

#### INDUSTRIAL APPLICABILITY

According to the present invention, by forming the outermost layer of the coated leather with a curable fluorine-containing resin, stain  
10 removability and solvent (ethanol) resistance are enhanced, and cold resistance and flexing fatigue resistance, lowering of which was cared by the use of fluorine-containing resin, can be maintained at a level of conventional urethane resin coating.